



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3198-1

Job Sheet 201556



Part No: D3198-1

Job Qty: 16 pcs

Part Name: Fitting



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/7/19

Job Tracking No:

Due Date: 10/25/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP: A 03.11.11 New Issue KJ/RF IPP Rev:B Now on Waterjet 07-01-09 JLM

Shlp Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier		Sign-off
							Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	16 pcs		10/25/19	0.17	1.04	Waterjet - Flow	6/17/19	JRB
120	QC 8	16 pcs		10/25/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
130	Small Fab - Brake NC - B4B	16 pcs		10/25/19	0.25	1.00	Small Fab - Brake - 1 - B4B		
							Small Fab - Brake - 2 -		

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 (613) 632-5200
Email: sales@dartaero.com
www.dartaero.com



Container No: S223694

Part: D3198-1

Job No: 201556

Serial No/Batch: S223694

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/17/19

OCT 21 2019
DAS
8-89

DAS
30
8-89

OCT 2 2019

Plex 10/7/19 1:11 PM Dart.lajeunesse.marie

10/7/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				B4B	
				Small Fab - Brake - 3 - B4B	
140 QC 5	16 pcs	10/25/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
					OCT 24 2019
150 Powdercoat - 3 Grey Sand - B4B	16 pcs	10/25/19	0.00 0.30	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
160 QC 3	16 pcs	10/25/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
					DAS 40 9-88
					OCT 25 2019
170 Packaging 3-1 - Stock - B4B	16 pcs	10/25/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	

Plex 10/7/19 1:11 PM Dart.lajeunesse.marie

Plex 10/7/19 1:11 PM Dart.lajeunesse.marie

10/7/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	7c 51021
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180	QC 21 - SA	16	10/25/19	0.00 0.00	QC 21 - SA - 21
		pcs			QC 21 - SA - 70
					QC 21 - SA - 53

OCT 28 2019
DAS
21
9-55

Part Op 100 - 1-Cut as per Dwg D3198
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - (Form as per dwg) 1-Deburr if necessary 2-Form as per Dwg D3198
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3) START TIME: _____
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S11GA	304/316 0.125 Sheet	1.6800 sf (.105 ea)	100-Waterjet - Flow - 1	5216338

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S11GA	2	62	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fitting	0.266inches + 0.006 - 0.001	0.272 0.265	0.267	
2	Fitting	4.280inches $\pm$ 0.010	4.290 4.270	4.285	
3	Fitting	2.500inches $\pm$ 0.010	2.510 2.490	2.506	
4	Fitting	3.420inches $\pm$ 0.010	3.430 3.410	3.425	
5	Fitting	0.400inches $\pm$ 0.010	0.410 0.390	0.4005	
6	Fitting	0.400inches $\pm$ 0.010	0.410 0.390	0.4004	
7	Fitting	3.880inches $\pm$ 0.010	3.890 3.870	3.882	
8	Fitting	2.100inches $\pm$ 0.010	2.110 2.090	2.099	
9	Fitting	3.020inches $\pm$ 0.010	3.030 3.010	3.025	

Plex 10/7/19 1:11 PM Dart.lajeunesse.marie



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐
Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QSI042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
☐	☐	☐	☐
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
☐	☐	☐	☐
Crushing	BOM/Route	Grain Direction	Drawing
☐	☐	☐	☐
Cracks	Broken/Damage/Defect	Weld	Finish
☐	☐	☐	☐
Crimp/kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
☐	☐	☐	☐
Marks/Chatter	Drill Holes	Out of Sequence	Misread
☐	☐	☐	☐
Mislabeled	Fit/Function	Off-set/Set-up	
☐	☐	☐	

Other/Details: _____